

Date: Wednesday, 26/11/2008 12:45:57 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT		
Job Number	: 43747			Part Number	: D2565301	
Estimate Number	: 10964			Drawing Number	: D2565 REV E	
P.O. Number	:			Project Number	: N/A	
This Issue	: 26/11/2008		S.O. No. :	Drawing Revision	: E	
Prsht Rev.	: NC			Material	:	
First Issue	: / /		Type :	SMALL /MED FAB	Due Date	: 10/12/2008
Previous Run	: 40680			Qty:	6	Um: Each
Written By	:					
Checked & Approved By	: JUD 08.11.26					
Comment	: Est: A 02.06.10 New Issue NG					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 2.3888 f(s)/Unit Total : 14.3325 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049)	<p>M 110 07 15 88 09/01/08 6</p>
2.0	BRAKE NC	NC BRAKE	
		Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313	<p>88 09/01/08 6</p>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill hole open to .316 Ø as per Dwg D2565 (one end only) Deburr	<p>FF 09-01-08 M 1 09/01/08 6X</p>
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<p>S 09/08 76</p>
5.0	POWDER COATING	POWDER COATING	
		Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3	<p>M 109996 6X</p>
		START TIME: <u>10:15</u>	
		OVEN TEMPERATURE: <u>400</u>	
		FINISH TIME: <u>10:45</u>	
			<p>M 1 09/01/09</p>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MS



09-09-01

JK

Comment: INSPECT POWDER COAT

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST253

09/01/12

JK

8.0 QC21

FINAL INSPECTION/W/O RELEASE



09/01/12 JK

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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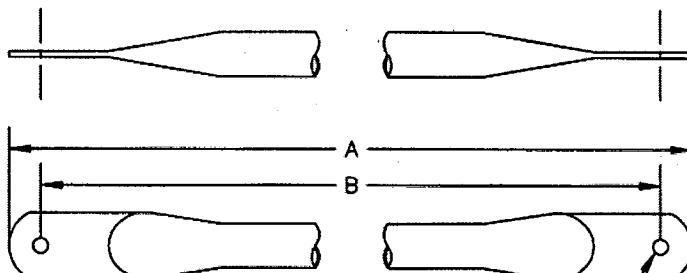
NOTE: Date & initial all entries

DARTCOPY IS
DRAFT

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2565 REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT SCALE 1:3

RELEASED

04.05.05



DIA 0.257 TO BE PUNCHED
 "C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	—
D2565-109	12.31	11.51	—
D2565-111	13.65	12.85	—
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	—
D2565-209	15.16	14.36	—
D2565-211	14.14	13.34	—
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	—
D2565-309	20.17	19.37	—
D2565-311	16.30	15.50	—
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	—
D2565-409	9.34	8.54	—
D2565-411	13.81	13.01	—

GENERAL NOTES

1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
 (REF. DART SPEC. M304TR0.750W0.049)

ENSURE SEAMLESS TUBE IS USED

2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 WITHOUT NOTICE
 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED WORK ORDER

4) ALL DIMENSIONS ARE IN INCHES

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ENGINEERING

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SUBJECT TO AMENDMENT

NO. 43747

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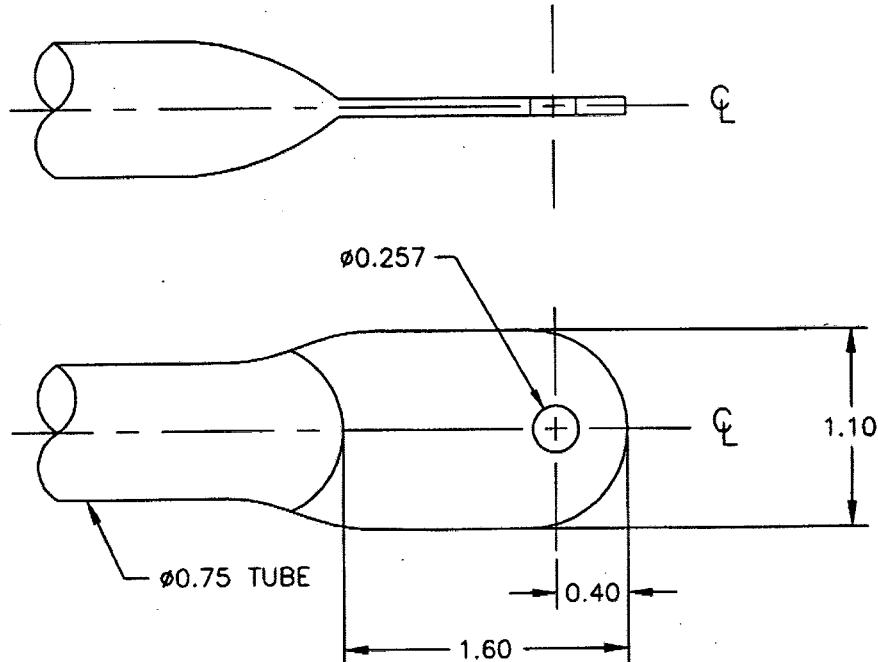
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
<i>DKY</i>	<i>JF</i>	D2638	SHEET 1 OF 1
DATE		TITLE	SCALE
98.04.28		PUNCH DT8117 SPEC CONTROL	1:1
A	98.04.28	NEW ISSUE	

RELEASED
48/07/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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